

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005777**Date Inspected:** 03-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Guo Yan Fei, Tu Jun, Qiguo You			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>

**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

**Bay 12**

This QA Inspector randomly observed the following work in progress in Bay 12:

FCAW welding of weld joints DP168-001-w1,w2,w3 located on PCMK 7AW. Welder was identified as 059421. ZPMC QC was identified as Guo Yan Fei (QC1). The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-repair-1.

**Bay 10**

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint NSD1-SA3-166C/F-10 located on PCMK north tower, lift 2, skin A. Welders were identified as 066825 and 067499. ZPMC QC was identified as Tu Jun (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-4322-Tc-P4-F. Also present at this location and appearing to be monitoring the welding was ABF Representative Liu Cheng.

**Bay 11**

This QA Inspector randomly observed the following work in progress in Bay 11:

SMAW welding of weld joints WSD1-SA355-A/D-11B located on PCMK west tower, lift 2, skin C. Welder was identified as 067138. ZPMC QC was identified as Qiguo You (QC3). The welding variables recorded by QC3 appeared to comply with WPS-B-T-2232-Tc-U5-F. Also present at this location and appearing to be monitoring

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the welding were ABF Representatives Luo Lai Quan and Chen Wen Liang.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

This QA inspector asked all three QC's noted above if all the welding variables observed by them appeared to comply with the appropriate WPS, including preheat and interpass temperature requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector that he was carrying the appropriate temperature sticks to monitor minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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